

When drilling the holes in the lugs in the friction sleeve *B*, Fig. 16, the block *D* and the hook-bolts are removed. It may be mentioned here, although it is a small matter, that these parts should be tied together when removed, and there should be a specified place where all the parts belonging to a particular jig should be kept when not in use. The friction sleeve *B* fits over the collar *G*, Fig. 18. This collar is an extra, piece, belonging to the jig, and used only when drilling the friction sleeve; it should be marked with instructions for what purpose it is used. The collar *G* fits over the projecting finished part // in

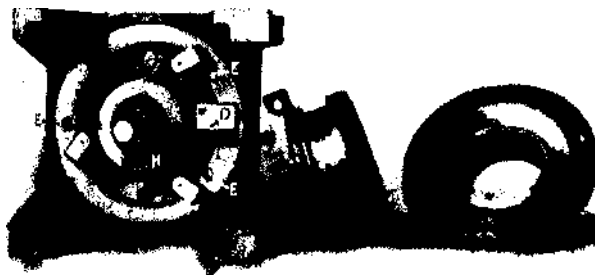


Fig. 17. Drill Jig shown in Fig. 16, with On© <*f tho IHftecu in Place

the center of the jig, and is located in its right position by the keyways shown. The key way in the friction sleeve // l_f which must be cut and placed in the right relation ft* the projecting lugs before the piece can be drilled, locates the sleeve on the collar *G*, which is provided with a corresponding keyway. A flange on the collar (/ , as shown more* plainly at / , in Fig. 18, locates the friction sleeve at the right, distance* from I lit* bottom of the jig, so that the holes will have* a proper location sideways. Two collars, *G* and *f*, are used for the pirn* II, this being necessary because the holes Af and If in tht* projecting tugs shown in Fig. 16 are not placed in the same

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